REV:				
A A	ENGINE	ERING DATA REQUIREMENTS (ATTACHMENT "A")		
NOTE: MILITARY SPECIFICATIO	DNS I/STANDARDS WILL NOT BE FURNISHED IN TI	UE AID DET		
	IONS ARE FURNISHED FOR THE MANUFACTURE O			
CYLINDER ASSEMBLY - INNER, TIP PROTECTION GEAR, B-52 ACFT				
2. PART NUMBER		3. NATIONAL STOCK NUMBER		
5-71661-503		1620-00-771-8827		
4. THE FOLLOWING SPECIFICA FURNISHED UNLESS SO INDICA	.TIONS/STANDARDS, ETC., WILL BE USED IN LIEU .TED.	OF THE DATA INDICATED. THE SUPERSEI	DED DATA WILL NOT BE	
TO SHIPMENT OF DISC	YSTEM ENGINEER RETAINS ALL RI CREPANT ITEMS. ALL DEVIATIONS WILL BE SUBMITTED FOR MRB DISI	S , MINOR OR MAJOR, FROM T		
6. PRIOR TO CONTRACT AWARD, THE CONTRACTOR WILL CERTIFY TO THE GOVERNMENT IN WRITING, FULL COMPLIANCE WITH MANUALS, SPECIFICATIONS, AND STANDARDS CALLED OUT AND REQUIRED FOR THE MANUFACTURE OF THIS CONTRACTED LANDING GEAR COMPONENT/ASSEMBLY. CONTRACTOR IS RESPONSIBLE TO COMPLETELY SEARCH THESE MANUALS, SPECIFICATIONS, AND STANDARDS AND FULLY UNDERSTAND THE REQUIREMENTS NECESSARY TO MANUFACTURE LANDING GEAR COMPONENTS. ANY QUESTIONS CAN BE FORWARDED TO THIS OFFICE OO-ALC/LGHLEN.				
	AWARD THE SUCCESSFUL BIDDER DUTING DOCUMENTS AND PROCES BEGINS.			
8. IDENTIFICATION A BAC 5307.	ND MARKING PER MIL-STD-130, IM	IPRESSION STAMPING NOT PE	RMITTED, IN LIEU OF	
9. DRAWING 2-5000, B THIS ITEM.	BACD 2041, BAC 5602, BAC 5004, ANI	D MIL-H-6088 ARE NOT REQUI	RED TO MANUFACTURE	
10. THREADS PER MII	L-S-7742, SAFETY CRITICAL.			
11. PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF MIL-I-6868. USE FULL WAVE DIRECT CURRENT (FWDC), WET CONTINUOUS METHOD, FLUORESCENT TYPE WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED. THE INTENT OF NO DEFECTS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE WILL BE NO INDICATIONS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTION WILL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURES DEVELOPED BY A LEVEL III AS SPECIFIED IN AIA/NAS 410.				
12. HEAT TREAT PER	SAE AMS-H-6875 IN LIEU OF BAC 50	601.		
13. ON PARTS HEAT TREATED 180 KSI AND ABOVE, ANY SURFACES GROUND/MACHINED AFTER HEAT TREAT WILL BE INSPECTED FOR BURNS PER MIL-STD-867. GRINDING WILL BE PER MIL-STD-866.				
14. THE FOLLOWING FINISH CODES APPLY TO THE MANUFACTURE OF THIS ITEM:				
A. F 1.10 APPLY NO FINISH EXCEPT THAT TEMPORARY COATINGS MAY BE APPLIED AS REQUIRED FOR PROTECTION DURING HANDLING, TRANSPORTATION AND STORAGE.				
B. F 1.20 CADMIU	M PLATE PER MIL-STD-870, CLASS	1, TYPE II. OPTIONAL F 1.205	NOT ALLOWED.	
PREPARED BY		SYMBOL	DATE	
CAROL HYER		LGMPM	21 Nov 03	

REV:	ENGINEERING DATA REQUIREMENTS CONTINUATION SHEET (ATTACHMENT "A")	
PART NUMBER	NATIONAL STOCK NUMBER	
5-71661-503	1620-00-771-8827	

- C. F 1.60 CADMIUM PLATE PER MIL-STD-870, CLASS 1, TYPE II. APPLY TWO PRIMER COATS EPOXY-POLYAMIDE PER MIL-PRF-23377 TO INTERIOR SURFACES EXCLUDING THE AXLE HOLE. OPTIONAL F 1.65 NOT ALLOWED.
- D. F 1.61 CADMIUM PLATE PER MIL-STD-870, TYPE III, CLASS 2, EXTERIOR SURFACES, SINGLE PLATE THICKNESS .0003" - .0005" EXCEPT AS NOTED. APPLY TWO PRIMER COATS EPOXY-POLYAMIDE PER MIL-PRF-23377 TO INTERIOR SURFACES.
- E. F 1.90 CHROMIUM PLATE TO DRAWING SPECIFIED THICKNESS TO MEET THE REQUIREMENTS OF QQ-C-320, CLASS 2.
 - F. F 12.46 ASSEMBLE WITH WET PRIMER PER TT-P-1757 ON FAYING SURFACES.
- 15. APPLY ONE COAT EPOXY-POLYAMIDE PRIMER PER MIL-PRF-23377, FOLLOWED WITH TWO TOP COATS POLYURETHANE PER MIL-PRF-85285, TYPE 1, COLOR #17925 (WHITE) PER FED-STD-595 TO THE EXTERIOR SURFACES OF P/N 5-36426-2 EXCLUDING THE AXLE HOLE.
- 16. USE SAE AMS 6484 FOR 4340 STEEL IN LIEU OF MIL-S-5000. (DWG 5-36426 & 3-80059)
- 17. USE SAE AMS 6382 FOR 4140 STEEL IN LIEU OF MIL-S-5626. (DWG 4-80076 & 3-80059)
- 18. USE SAE AMS 6280 FOR 8630 STEEL IN LIEU OF MIL-S-6050. (DWG 4-80076)
- 19. MACHINE USING BEST AIRCRAFT INDUSTRY SHOP PRACTICES IN LIEU OF BACD 2097.
- 20. DRILLING, REAMING AND HONING TO MEET DRAWING SPECIFICATIONS, USING BEST SHOP PROCEDURES AND THE FOLLOWING NOTES:
 - A. HIGH SPEED STEEL (HSS) DRILLS SHALL BE USED TO DRILL CORROSION RESISTANT STEELS.
- B. HSS REAMS WILL BE USED FOR ROUGH REAMING AND FINAL REAMING OF STEELS HEAT TREATED BELOW 200 KSI. CARBIDE OR PREMIUM GRADE HI-SPEED STEEL TIPPED REAMERS WILL BE USED FOR ROUGH REAMING OF STEELS HEAT TREATED ABOVE 200 KSI.
- C. HONING STONES SHALL BE OF 150 TO 500 ALUMINUM OXIDE GRIT WITH A MEDIUM-HARD BOND AND PREFERABLY A MULTI-HEAD STONE.
- D. DRILLING SHALL NEVER BE USED AS A FINAL MACHINING OPERATION. A MINIMUM OF 0.015 INCH ON DIAMETER SHALL BE LEFT FOR FINAL REAMING. HOLES SHALL BE FINISHED BY REAMING OR BORING. WHEN JIGS, FIXTURES OR BUSHINGS ARE NOT USED FOR DRILLING HOLES LARGER THAN 1/4 INCH, THE HOLES WILL BE PILOTED WITH A CENTER DRILL. CHEMICAL, ELECTRICAL OR ELECTROCHEMICAL HOLE PRODUCING METHODS SHALL NOT BE USED AS A FINAL SURFACE PRODUCING METHOD WITHOUT PRIOR APPROVAL FROM OO-ALC/LILEC.
- E. ROUGH REAMING, THE REAMER LENGTH SHALL BE AS SHORT AS CONSISTENT WITH REQUIRED PENETRATION. FINAL REAMING, THE DIAMETRAL CUT SHALL PRODUCE A HOLE THAT MEETS THE REQUIREMENTS OF THE ENGINEERING DRAWING.

PREPARED BY	SYMBOL	DATE
CAROL HYER	LGMPM	21 Nov 03
OO-ALC FORM 462, OCT 96 (EF-V1) (PerFORM PRO)		PAGE 2 OF 3

REV:	ENGINEERING DATA REQUIREMENTS CONTINUATION SHEET (ATTACHMENT "A")
PART NUMBER	NATIONAL STOCK NUMBER
5-71661-503	1620-00-771-8827

- F. HONING SHALL BE USED AS A FINAL OPERATION WHERE A SURFACE FINISH BETTER THAN 125 ROUGHNESS HEIGHT RATIO IS REQUIRED AND CANNOT BE PRODUCED BY OTHER MEANS.
- G. CARBIDE DRILLS CAN BE OPERATED AT HIGHER SPEEDS THAN HSS DRILLS, BUT MUST BE USED WITH CAUTION. THEY MUST NOT BE USED IN A DULL OR CHIPPED CONDITION.
- 21. THE REQUIRED FORGING WILL BE PROCURED FROM THE QUALIFIED FORGING SOURCE USING THE ORIGINAL CERTIFIED FORGING PROCEDURES AND DIES/TOOLING.
- A. PRIOR TO CONTRACT AWARD, THE DETAIL PART BIDDER SHALL PROVIDE CERTIFICATION, FROM THE FORGING SOURCE, TO THE GOVERNMENT THAT THE CERTIFIED DIES AND FORGING PROCEDURES ARE AVAILABLE AND THE FORGING SOURCE HAS AN AGREEMENT WITH THE DETAIL PARTS BIDDER TO PROVIDE FORGINGS FOR THEIR USE IN THE EVENT THEY ARE THE SUCCESSFUL BIDDER.
- B. PRIOR TO PRODUCTION, FORGING LOT QUALIFICATION WILL BE ACCOMPLISHED AS SPECIFIED ON THE FORGING DRAWING AND SAE AMS-F-7190 FOR STEEL FORGINGS AND SAE AMS-A-22771 FOR ALUMINUM FORGINGS. THE DETAILED PART CONTRACTOR SHALL ASSURE THAT THIS HAS BEEN ACCOMPLISHED BY THE FORGING SOURCE AND SHALL SUBMIT CERTIFIED DOCUMENTATION OF ACCOMPLISHMENT TO THE GOVERNMENT.
- 22. FORGING SOURCE, DIE NUMBER AND LOCATION OF DIES:
 - A. FORGING DRAWING: BOEING AIRCRAFT CO 5-36426-2 DIE NUMBER: UNKNOWN
 - B. CONTROL OF FORGING PROCESSES: UNKNOWN
 - C. LOCATION OF FORGING DIES: UNKNOWN
- 23. INSTRUCTIONS FOR QUALIFICATION OF NEW FORGING SOURCE:

PRIOR TO CONTRACT AWARD, THE CONTRACTOR WILL ADVISE THE GOVERNMENT IN WRITING OF THEIR INTENT TO PROCURE NEW FORGING DIES AND THE PROPOSED FORGING SOURCE. THE CONTRACTOR WILL NOT PROCEED TO OBTAIN NEW DIES WITHOUT THE EXPRESS CONSENT OF THE GOVERNMENT PROCURING AGENCY. THE GOVERNMENT WILL HAVE UNLIMITED USE OF THE DIES DEVELOPED UNDER THIS CONTRACT. THE CONTRACTOR WILL INFORM THE FORGING HOUSE IN WRITING, AT THE SAME TIME THE ORDER FOR THE DIES IS PLACED, THAT THE GOVERNMENT HAS UNLIMITED USE RIGHTS OF THE DIES AND FORWARD A COPY OF THIS LETTER TO THE CONTRACTING OFFICER.

24. USE NSN: 5310-01-073-8613, P/N: AN365-428, CAGE: 88044, SELF LOCKING NUT IN LIEU OF BAC-N10BY-54W.

PREPARED BY	SYMBOL	DATE	
CAROL HYER	LGMPM	21 Nov 03	
		PAGE 5 OF 3	

REV:		FAIGN	TESTINO DATA DEGLIDERACITA	_	
	В	ENGIN	IEERING DATA REQUIREMENTS (ATTACHMENT "A")	>	
NOTE:	: MILITARY SPECIFICAT	TIONS I STANDARDS WILL NOT BE FURNISHED II	IN THE BID SET.		
1. TH	E FOLLOWING INSTRUC	CTIONS ARE FURNISHED FOR THE MANUFACTUR	RE OF		
		CYLINDER, OUTER - STRUT			
2. PA	ART NUMBER		3. NATIONAL STOCK NUMBER		
	4G11415-10		1620 00 446 3776		
4. TH	IE FOLLOWING SPECIFIC ISHED UNLESS SO INDIC	CATIONS/STANDARDS, ETC., WILL BE USED IN L CATED.	IEU OF THE DATA INDICATED. THE SUPER	REDED DATA WILL NOT BE	
a.	Machine to meet	drawing requirements per LAC 0701, in	n lieu of DS 30003.		
b.	b. Identify to meet drawing requirements and MIL-STD-130 with the following notes, in lieu of STP 63-001. Serial number shall be vibropeened, in the location indicated. If the drawing does not indicate a location, OO-ALC/LILE will provide S/N location instructions. Serialization of item shall be accomplished as follows: The serialization will begin with the CAGE of the contractor named on the contract, followed by a dash and the two (2) digit year of manufacture, followed a dash and a sequentially unique three (3) digit number. A contractor who receives numerous intermittent contracts will start serialization of item with the next number in sequence of the prior contract. If a contract produces more than 1000 items, the serial number should appear like this: "S/N 98747-02-001"				
c.	c. Magnetic particle inspection per ASTM E1444, in lieu of MIL-I-6868. Use fluorescent type, full wave direct current (FWDC), and wet continuous method. With the following acceptance/rejection criteria: NO DEFECTS ALLOWED. The intent of NO DEFECTS ALLOWED is that the inspection is conducted at the required sensitivity level and there shall be no indications allowed. The inspector performing the inspection shall be level II certified, with the inspection procedure developed by a level III, as specified in NAS-410.			DEFECTS ALLOWED. sensitivity level and there	
d.	acceptance/rejection is conc	per ASTM E1417, Type I, Method B or tion criteria: NO DEFECTS ALLOWER ducted at the required sensitivity level ar aspection shall be level II certified, with	D. The intent of NO DEFECTS AL nd there shall be no indications allow	LOWED is that the wed. The inspector	
e.	Shot peen to mee	et drawing requirements per SAE AMS-S	S-13165, in lieu of STP 51-501.		
f.	Heat treat, normal	lize, stabilize, and anneal, per SAE AM	.S-H-6875; in lieu of STP 54-006.		
g.	Any surface grow MIL-STD- 867. (nd/machined after heat treat, shall be ins Grinding shall be per MIL-STD-866.	spected for abusive grinding/machin	ning burns per	
5. T	The following chang	ges have been made in materials and spec	cifications required.		
a.	Use SAE AMS 48 drawings 4G1367	881, in lieu of AMS 4881. Alternate mat (3, and 4G13675)	terial use SAE AMS 4590, in lieu o	f AMS 4590. (Ref.	
b.	Use SAE AMS 48	881, in lieu of AMS 4881. (Ref. drawin	ngs 4G13382, 4G13591, and 4G136	672)	
c.	Use ASTM B271	Alloy C95410, in lieu of QQ-B-671. (Ref. drawing 4G13588)		
PREPAR	IED BY		SYMBOL	DATE	
	ORIN H	IATCH	LGMPM	9 Dec 03	

REV:		ENGINEERING D	ATA REQUIREMENTS CONTINUATION	N SHEET
	В		(ATTACHMENT "A")	
PART	IUMBER	70	NATIONAL STOCK NUMBER	
	4G11415-10	//C	1620 00 446 3776	
d.	Use ASTM B196,	in lieu of QQ-C-530, and SAE AMS 4	4881, in lieu of AMS 4881. (Ref. d	rawing 4G13385)
e.	Use ASTM B150 alloy C63000, in lieu of QQ-C-465, alternate material use ASTM B271 Alloy C95400, in lieu of QQ-C-390. (Ref. drawing 4G13612)			
f.	Use ASTM B196	Alloy 17300 Temper TF00, in lieu of	QQ-C-530. (Ref. drawing 4G13611)
g.	Use SAE AMS 62	57, in lieu of STM 05-501. (Ref. draw	ring 4G13400)	
h.	Assemble wet usin	ng TT-P-1757, in lieu of MIL-P-8585.	Ref. drawing 4G11415)	
6. I	nstall bushings per t	he following for sub zero shrinkage re	quirements. (Ref. drawing 4G1141	5 note 33)
a.	housing into which installation, such a	lation shall be accomplished in such a real than the bushing is installed, or the finish as the use of a press or hammer is not possible bushing into alignment with the heart of the bushing into alignment.	on the O.D. of the bushing. Forced ermitted, and is not acceptable. A s	l installation of sub-zero
Ъ.	Prior to bushing in	nstallation, the parts and housing bore s	shall be cleaned with a solvent to re	move all contamination.
c.	by OO-ALC/LILE	all be used for all sub-zero installations engineering. The soak time of the bus ne same temperature as the coolant.	unless some other sub-zero coolan hing in the liquid nitrogen shall be	t is specified, and approved sufficient to allow the
d.	The bushing shall be installed into the housing immediatedly upon removal from the coolant with an absolute minimum lost time. Trial runs shall be accomplished as necessary to minimize installation time, which should be in the order of about seven (7) seconds maximum.			with an absolute minimum should be in the order of
e.	It may occasionally be necessary to heat the housing into which the bushing is to be installed, in addition to sub-zero cooling of the bushing. Detail parts in process, which do not have paint or sealant or other organic material applied prior to heating, the parts shall be heated by the use of radiant heat techniques, such as thermal blankets, infrared lamps etc; to the maximum temperature of 250 F. Temperature measuring devices shall be used to monitor heat and shall be located on areas of the part expected to reach maximum temperature. No scaling, oxidation, or corrosion shall be permitted.			
	f. The shrunken part shall be installed into the housing bore which has received a wet coat of TT-P-1757, zinc chromate primer which has been brush applied. The primer shall be applied to the housing bore prior to installation, so as to insure complete sealing of gaps between the housing bore and the installed bushing as evidenced by extruded primer around the entire periphery of both ends of the bushing.			
PREPARE	D BY		SYMBOL	DATE
	OR	IN HATCH	LGMPM	9 Dec 03

REV:		ENGINEERING C	DATA REQUIREMENTS CONTINUATION	W OHER
	В		(ATTACHMENT "A")	N SHEET
PART	NUMBER		NATIONAL STOCK NUMBER	
	4G11415-107C		1620 00 446 3776	
7. I	Drilling, reaming, an STP 51-410.	nd honing to meet drawing specifications	is, using best shop procedures and	the following notes in lieu of
a.	High speed steel (!	(HSS) drills shall be used to drill corrosic	ion resistant steels.	-
b.	HSS reamers will be premium grade his:	he used for rough reaming, and final rea- speed tipped reamers will be used for ro	aming of steels heat treated below a ough reaming of steels heat treated	200 KSI. Carbide or above 200KSI.
c.	Honing stones shall Heads with steel sh	Il be of 150 to 500 aluminum oxide grit shoes or wipers shall not be used.	with a medium-hard bond and pre-	ferably a multi-head stone.
d.	reaming. Holes shall larger than 1/4 inch	or be used as a final machining operation, all be finished by reaming or boring. When, the holes will be piloted with a center be used as a final surface producing method.	hen jigs, fixtures, or bushings are it drill. Chemical, electrical, or elec	not used for drilling holes
e.	Rough reaming, the cut shall produce a	ne reamer length shall be as short as cons a hole that meets the requirements of the	sistent with required penetration. Fe engineering drawing.	Final reaming, the diameter
f.	Honing shall be use cannot be produced	sed as a final operation where a surface fi d by other means	finish better than 125 roughness he	ight ratio is required, and
g.	Carbide drills can be dull or chipped con	be operated at higher speeds that HSS dradition.	rills, but must be used with caution	n. Thay must not be used in
8. F	inish per the followi-	ing in lieu of DS 30000, and finish code	e C, CC, D, 17, 54, and 74-74.	
a.	Cadmium plate per	r MIL-STD-870, or QQ-P-416 to meet d	drawing requirements Class 2, Typ	e II. (code C)
b.	Cadmium-titanium (code CC)	plate per MIL-STD-1500, or SAE AMS	S 2419, to meet drawing requireme	ents Class 2, Type II.
c.	Chromium plate pe-	er MIL-STD-1501, Type II, Class 1. (coo	ode D)	
d.	Primer wash is not	required for the manufacture of this item	m. (code 17)	
e.	One coat of epoxy p MIL-PRF-23377, T	primer per MIL-PRF-85582, Type I, Cla Type I.	lass C 2. (code 54). Alternate, Oi	ne coat of epoxy primer per
f	Two coats of top co	oat per MIL-PRF-85285, Type I. (color	white, No. 17925 per FED-STD-5	595). (code 74-74)
REPARE		İ	SYMBOL	DATE
	ORIN HATCH LGMPM 9 Dec 03			

REV:					
В	ENGINEERING I	DATA REQUIREMENTS CONTINUATION (ATTACHMENT "A")	SHEET		
PART NUMBER		NATIONAL STOCK NUMBER			
4G11415-107C		1620 00 446 3776			
9. The required forgings dies.	9. The required forgings will be procured from the qualified forging source using the original certified forging procedures and dies.				
the certified dies a	a. Prior to contract award, the detail part bidder will provide certification, from the forging source to the government, that the certified dies and forging procedures are available and that the forging source has an agreement with the detail part bidder to provide forgings for his use in the event that he is the successful bidder.				
SAE AMS-F-719	on, forging lot qualification will be accommod. The contractor will assure that this intation of accomplishment to the government.	s or has been accomplished by the f	g drawing, and orging source and will submit		
10. FORGING SOURCE	E. CONTROL AND LOCATION OF	DIES:			
a. Forging drawing:	4G13400-991A Lockheed	GA. CAGE 98897			
b. Control of froging	B.F Goodri	ch CAGE 13002			
c. Location of frogin	105 Madiso	n St.			
d. Die number: 1533	Worcester,	MA 01013			
11. Material Review Box	ard disposition:				
 a. OO-ALC/LILE sy discrepant item. A disposition. 	stem engineering retains all rights to re	view and accept MRB dispositions ne engineering drawing package will	prior to shipment of be submitted for MRB		
specifications, and assembly. The con	b. Prior to contract award, the contractor will certify to the government in writing full compliance with manuals, specifications, and standards called out and required for the manufacture of this contracted landing gear component/ assembly. The contractor is responsible to completely search all required documents and fully understand the necessary requirements to manufacture the stated item. Any questions can be forwarded to this office OO-ALC/LILE				
12. After contract award process specifications	the successful bidder shall provide a cos) to LILE for final review before prod	opy of the processing documentation uction begins.	(routing documents and		
13. The following specif	ications are not required for manufatetr	e of this item.			
a. Fatigue test X998,	Static test X999, and DS 5025.				
b. Flag notes 60 and 61 on drawing 4G11415 are not required.					
PREPARED BY		SYMBOL	DATE		
ORIN HATC	'H	LGMPM	9 Dec 03		

REV:				
	С	ENGINEERING DATA REQUIREMENTS (ATTACHMENT "A")		
<i>NOTE:</i> 1. THI	MILITARY SPECIFICATI	ONS I/STANDARDS WILL NOT BE FURNISHED IN TIONS ARE FURNISHED FOR THE MANUFACTURE	THE BID SET. OF	
		PISTON, AXLE - STRUT AS		
2. PAI	RT NUMBER		3. NATIONAL STOCK NUMBER	
	4G51427-101 1620 00 409 4739			
4. THE	FOLLOWING SPECIFICA	ATIONS/STANDARDS, ETC., WILL BE USED IN LIER ATED.	U OF THE DATA INDICATED. THE SUPER	RSEDED DATA WILL NOT BE
a.		0701, in lieu of DS 30003.		
b.	b. Identify to meet drawing requirements and MIL-STD-130 with the following notes, in lieu of STP 63-001. Serial number shall be vibropecned, or steel stamped, in 0.09" letters 0.004" - 0.007" deep in the location indicated. If the drawing does not indicate a location, OO-ALC/LILE will provide S/N location instructions. Serialization of item shall be accomplished as follows: The serialization will begin with the CAGE of the contractor named on the contract, followed by a dash and the two (2) digit year of manufacture, followed by a dash and a sequentially unique three (3) digit number. A contractor who receives numerous intermittent contracts will start serialization of item with the next number in sequence of the prior contract. If a contract produces more than 1000 items, the serial number should appear like this: "S/N 98747-95-001"			
c.	Heat treat per SAE shall be inspected	E AMS-H-6875, in lieu of STP 54-006, a for burns per MIL-STD-867, grinding s	and STP 54-013. Any surface grou shall be per MIL-STD-866.	and/machined after heat treat
d.	Magnetic particle inspection per ASTM E1444, in lieu of MIL-I-6868. Use fluorescent type, full wave direct current (FWDC), and wet ontinuous method. With the following acceptance/rejection criteria: NO DEFECTS ALLOWED. The intent of NO DEFECTS ALLOWED is that the inspection is conducted at the required sensitivity level and there shall be no indications allowed. The inspector performing the inspection shall be level II certified, with the inspection procedure developed by a level III, as specified in NAS-410.			
e.	Shot peen to meet	drawing requirements per SAE AMS -S-	-13165, in lieu of STP 51-501.	
f.	Machine per SAE AND 10071. (Ref	AS 33515-4, or SAE AS 5202-4, in lieu drawing 4G51427)	of AND 10050-4, and use SAE	AS 5202-5 in lieu of
5. T	he following are ma	terial changes.		
a.	Use SAE AMS 625	57, or SAE AMS 6419, 300M in lieu of S	STM 05-501. (Ref. drawing 4G5	1404)
b.	Use SAE AMS 564	43 17-4PH, in lieu of AMS 5643. (Ref. o	drawing 4G53912)	
C.	Use TT-P-1757, in	lieu of MIL-P-8585.		
PREPARE	ED BY	[5	SYMBOL	DATE
	ORIN HATCI	Н	LGMPM	7 Dec 03
00-AI	C FORM 462, O	CT 96 (EF-V1)(PerFORM PRO) PRI	EVIOUS EDITIONS ARE OBSOLETE	PAGE 1 OF 4

REV:		ENGINEERING DA	ATA REQUIREMENTS CONTINUATION SHEET	
	С		(ATTACHMENT "A")	
PART N	IUMBER		NATIONAL STOCK NUMBER	
	4G51427-10	1A	1620 00 409 4739	
	Orilling, reaming, a TP 51-410.	nd honing to meet drawing specifications	s, using best shop procedures and the following notes in lieu of	
a.	High speed steel (HSS) drills shall be used to drill corrosion	on resistant steels.	
b.	b. HSS reamers will be used for rough reaming, and final reaming of steels heat treated below 200 KSI. Carbide or premium grade hi-speed tipped reamers will be used for rough reaming of steels heat treated above 200 KSI.			
c.		all be of 150 to 500 alumium oxide grit values or wipers shall not be used.	with a medium-hard bond and preferably a multi-head stone.	
d.	Drilling shall never be used as a final machining operation. A minimum of 0.015 inch on diameter shall be left for final reaming. Holes shall be finished by reaming or boring. When jigs, fixtures, or bushings are not used for drilling holes larger than 1/4 inch, the holes will be piloted with a center drill. Chemical, electrical, or electrochemical hole producing methods shall not be used as a final surface producing method without prior approval from OO-ALC/LILE.			
e.	Rough reaming, the reamer length shall be as short as consistent with required penetration. Final reaming, the diameter cut shall produce a hole that meets the requirements of the engineering drawing.			
f.	-	ised as a final operation where a surface to do by other means.	finish better than 125 roughness height ratio is required, and	
g.	Carbide drills car dull or chipped c		drills, but must be used with caution. Thay must not be used in	

- 7. Finish per the following in lieu of DS 30000, and finish codes C, CC, D, 46, 17, 54, and 74-74.
- a. Cadmium plate per MIL-STD-870, Class 3, Type II. (code C) (Ref. drawing 4G51427)
- b. Cadmium plate per MIL-STD-870, Class 2, Type II. (code CC) (Ref. drawing 4G51427)
- c. Chromium plate per MIL-C-1501, Type II, or III, Class 1. (code D) (Ref. drawing 4G51427 Note 9)
- d. Use SAE AMS 27725, Polyurethane coating. (code 46) (Ref. drawing 4G51427 Note 31)
- e. Primer wash is not required. (code 17)
- f. One coat of epoxy primer per MIL-PRF-85582, Type I, Class 2. (code 54). Alternate, One coat of epoxy primer per MIL-PRF-23377. Type I.
- g. Two coats of top coat per MIL-PRF-85285, Type I. (color white, No. 17925 per FED-STD-595). (code 74-74)

PREPARED BY	SYMBOL	DATE
ORIN HATCH	LGMPM	7 Dec 03

wing for product qualification must certify that the qualified of this requirement. CAGE 09455, RBC Transport e to the finish on the I.D. of the g. Forced installation of sub-zero onable. A small non-metallec hammer bushing. vent to remove all contamination. ero coolant is specified, and approved a shall be sufficient to allow the
wing for product qualification bust certify that the qualified sily this requirement. CAGE 09455, RBC Transport e to the finish on the I.D. of the lig. Forced installation of sub-zero stable. A small non-metallec hammer bushing. vent to remove all contamination. ero coolant is specified, and approved in shall be sufficient to allow the
e to the finish on the I.D. of the g. Forced installation of sub-zero otable. A small non-metallec hammer bushing. vent to remove all contamination. ero coolant is specified, and approved a shall be sufficient to allow the
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g. Forced installation of sub-zero ptable. A small non-metallec hammer bushing. vent to remove all contamination. ero coolant is specified, and approved a shall be sufficient to allow the
g. Forced installation of sub-zero ptable. A small non-metallec hammer bushing. vent to remove all contamination. ero coolant is specified, and approved a shall be sufficient to allow the
ero coolant is specified, and approved a shall be sufficient to allow the
n shall be sufficient to allow the
a applient with an absolute minimum
ne coolant with an absolute minimum ne, which should be in the order of
be installed, in addition to sub-zero nt or other organic material applied ch as thermal blankets, infrared lamp be used to monitor heat and shall be oxidation, or corrosion shall be
t coat of TT-P-1757, zinc chromate core prior to installation, so as to as evidenced by extruded primer
ir ic

SYMBOL

LGMPM

DATE

7 Dec 03

ORIN HATCH

PREPARED BY

REV:	ENGINEERING DA	ATA REQUIREMENTS CONTINUATION	SHEET	
С		(ATTACHMENT "A")		
PART NUMBER		NATIONAL STOCK NUMBER		
4G51427-1017	A	1620 00 409 4739		
10. The required forging and dies.	ngs will be procured from the qualified fo	orging source using the original cer	tified forging procedures	
the certified dies	award, the detail part bidder will provide and forging procedures are available and forgings for his use in the event that he	that the forging source has an agre-		
MIL-F-7190. The	on, forging lot qualification will be accorded contractor will assure that this is or has attation of accomplishment to the government.	been accomplished by the forging	-	
11. FORGING SOURC	E, CONTROL AND LOCATION OF D	IES:		
a. Forging drawing	: 4G51404-991A Lockheed (GA. CAGE 98897		
b. Control of forging	ng: B.F.Goodrich. CAGE 13	002		
c. Location of forgin		E 79448		
12. Material Review Box	12. Material Review Board disposition:			
	stem engineering retains all rights to rev Ill deviations, minor and major, from the		-	
specifications, and assembly. The cor	ward, the contractor will certify to the god standards called out and required for the tractor is responsible to completely search anufacture the stated item. Any questions	e manufacture of this contracted lan ch all required documents and fully	ding gear component/ understand the necessary	
13. After contract award the successfull bidder shall provide a copy of the processing documentation (routing documents and process specifications) to LILE for final review before production begins.				
14. The following specifications are not required for the manufacture of this item.				
a. DS 5025, Fatgue test X995, and Static test X999.				
b. Disregard flag no				
·				
PREPARED BY		SYMBOL	DATE	
ORIN HATCH	İ	LGMPM	7 Dec 03	
		<u> </u>	PAGE 14 OF 19	

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	REVISION:	02						ENC	ENGINEERING DA	DATA LIST		* HISTORY *
DATE	10DEC03	DATA TECH:	SOH	0	RGN S	ORGN SYMBOL	11	LGMPM	PR NR :	NR:	APPLICATION: C-5A/B	PAGE 1 OF 1
CAGE: 98897	MANUFACTURER NAME LOCKHEED MARTIN	RER NAME: MARTIN					A A	REFERENCE NR: 4G51427-101A	CE NR: 101A	NOUN : PISTON	NOUN : PISTON,LANDING GEAR	NSN: 1620004094739LE
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98897	98897 4G51404		_	i o	0001	0000	s	PIS	PISTON, AXLE			
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98747	98747 77C328		-	ŏ	1000	0000	s	ENG	ENGINEERING CHANGE ORDER			
98897	98897 DS 30001		\	ŏ	0000	0000	S	DES	DESIGN STANDARD			
98897	98897 LAC 0701		-	ŏ	0000	0000	s	PRO	PROCESS SPECIFICATION			
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									FURNISHED	WITH CONTRACT AWARD.	(NOT PROVIDED).	-

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RE	A/r	T			
ne	B	ENGINE	EERING DATA REQUIREMENTS (ATTACHMENT "A")	;	
NO	THE FOLLOWING INSTRUCT	ONS I/STANDARDS WILL NOT BE FURNISHED IN TIONS ARE FURNISHED FOR THE MANUFACTUR	V THE BID SET.		
		AIN LANDING GEAR	F-15		
	PART NUMBER		3. NATIONAL STOCK NUMBER		
	3A412704-1003		1620-01-445-0092		
4.	THE FOLLOWING SPECIFICA	ATIONS/STANDARDS, ETC., WILL BE USED IN LI		ISFDED DATA WILL NOT BE	
FUF	RNISHED UNLESS SO INDICA	ATED.		ococo agrico macino. De	
Α.	Mark and Identify pe	er MIL-STD-130 as an alternate to PS16	6001. (REF. NOTE #19)		
В.	vibropeened, in 0.09" OO-ALC/LGHLEN v follows: The serializ digit year of manufac numerous intermittent contract produces mo	and components utilize the following start letters 0.004"-0.007" deep in the local will provide S/N location instructions. Exation will begin with the CAGE of the cture, followed by a dash and a sequential contracts will start serialization of ite ore than 999 items, the serial number shorts: S/N 98747-03-001."	ation indicated. If the drawing does Serialization of item shall be accom- contractor named on the contract, ially unique 3 digit number. A con- em with the next number in sequence	not indicate a location, applished as followed by a dash and the 2 tractor who receives the of the prior contract. If a	
C.	Inspection requirement	nts are as follows:			
	with the following ALLOWED" is the allowed. The inspection	ent penetrant inspection per ASTM E14 g acceptance/rejection criteria: NO DE that the inspection is conducted at the rejector performing the inspection shall be specified in NAS 410.	FECTS ALLOWED. The intent of equired sensitivity level and there w	"NO DEFECTS vill be no indications	
	2. Perform Magnetic ParticleInspection per ASTM E1444 in lieu of PS 21201. Use full wave direct current (FWDC), wet continuous method, fluorescent type with the following acceptance/rejection criteria: NO DEFECTS ALLOWED. The intent of NO DEFECTS ALLOWED is that the inspection is conducted at the required sensitivity level and there shall be no indications allowed. The inspector performing the inspection shall be certified to Level II with the inspection procedure developed by a Level III as specified in NAS-410.				
D.). Shot Peen per SAE AMS -S-13165 as an alternate to PS 14023. (Insure all requirements of Drawing 68A412704, Note #27 are complied with).				
Ε.	. Heat Treat Beryl Copper per SAE AMS-H-7199 as an alternate to PS 15935. (DRAWING 68A410636, Note #13)				
F .	. Heat Treat Steel per SAE AMS-H-6875 as an alternate to PS 15296 and PS 15351.				
3.	For parts Heat-Treated to 180 KSI and above, any surface that is ground/machined after heat treat, shall be inspected for abusive grinding/machining burns per MIL-STD-867.				
┨.	Grind per MIL-STD-86	66 as an alternate to PS 20710.			
. 7	Femper Etch per MIL-S	STD-867 as an alternate to PS 21205.			
. E	Bearing General Specific	cation Qualifications MIL-B-81934 has	been cancelled, use SAE AS 8193	4.	
REP	PARED BY		SYMBOL	DATE	
'ΑC	VID H. ARGYLE		LGMPM	25 Nov 03	

REV:	ENGINEERING DATA REQUIREMENTS CONTINUATION SHEET	
В	(ATTACHMENT "A")	
PART NUMBER	NATIONAL STOCK NUMBER	
68A412704-1003	1620-01-445-0092	

- K. Install Bushings per the following, as an alternate to PS 17034:
 - 1. The bushing installations shall be accomplished in such a manner as to avoid damage to the finish on the I.D. of the housing into which the bushing is installed, or the finish of the O.D. of the bushing. Forced installation of sub-zero installations, such as the use of a press or hammer is not permitted, and is not acceptable. A small non-metallic hammer may be used to tap the bushing into alignment with the housing bore, or to seat the bushing.
 - 2. Prior to bushing installation, the parts and housing bore shall be cleaned with a cleaning solvent to remove all contamination.
 - 3. Liquid nitrogen shall be used for all sub-zero installations unless some other sub-zero coolant is specified, and approved by OO-ALC/LGHLEN Engineering. The soak time of the bushing in the liquid nitrogen shall be sufficient to allow the bushing to reach the same temperature as the coolant.
 - 4. The bushing shall be installed into the housing immediately upon removal from the coolant with an absolute minimum of lost time. Trial runs shall be accomplished as necessary to minimize installation time which should be in the order of about seven (7) seconds maximum.
 - 5. It may occasionally be necessary to heat the housing into which the bushing is to be installed, in addition to sub-zero cooling of the bushing. Detail parts in process, which do not have paint or sealant or other organic material applied prior to heating, shall be heated by the use of radiant heat techniques, such as thermal blankets, infrared lamps etc.; to the maximum temperature of 250 F.Temperature measuring devices shall be used to monitor heat and shall be located on areas of the part expected to reach maximum temperature. No scaling oxidation, or corrosion shall be permitted.
 - 6. Bushings without flanges shall be installed into housing bore which has received a light coat of sealant per MIL-PRF-81733. Install shrunken bushing and wipe off any excess sealant that may have extruded around the periphery of both ends of the bushings.
 - 7. Bushings with flanges shall be installed in a similar manner as paragraph F. Except sealant shall also be applied to face of lug under flange. Sealant shall be applied in such a manner as to ensure complete coverage of inside face of bushing flange when bushing is installed. Wipe off any excess sealant around periphery of bushing flange forming a bead. Wipe any excess sealant from the other end of the bushing.
 - 8. For bushings with external grease grooves the inside of the lug will be coated with MIL-C-16173 prior to bushing installation, and face of lug will be coated with MIL-PRF-81733 per paragraph G.

PREPARED BY	SYMBOL	DATE	
DAVID H. ARGYLE	LGMPM	25 Nov 03	
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REV	v: B	ENGINEERING DA	ATA REQUIREMENTS CONTINUATION SHEET (ATTACHMENT "A")	
PAF	RT NUMBER		NATIONAL STOCK NUMBER	
68/	8A412704-1003		1620-01-445-0092	
L.	Use Material SAE A	MS 6419 in lieu of AMS 6419. (DRAWI	ING 68A412704)	
M.	. Use Material SAE A	AMS-225/9 in lieu of QQ-A-225/9. (DRA	AWING 68B410067)	
N.	Use Material ASTM	B196, ASTM B197, and B194 in lieu of	f QQ-C-530, Condition "H". (DRAWING 68A410636)	
Ο.	Threads per MIL-S-8	8879. (SAFETY CRITICAL)		
P.	Cadmium Plate per N	MIL-STD-870 (Type II, Class 2) as an alte	ernate to PS 13101 & PS 13144.	
Q.	Chrome Plate per MI	IL-STD-1501(Type II, Class 3) as an alte	ernate to PS 13102.	
R.	Anodize per MIL-A	-8625 (TYPE II, CLASS I) as an alternate	e to PS 13201.	
S.	Phosphate Coat per I	MIL-DTL-16232 as an alternate to PS 133	205.	
Т.	Ion Vapor Deposit A	luminum (IVD) per MIL-DTL-83488 as a	an alternate to PS 13143.	
U.	U. Finish Specification 68A900000 and 40M114 are not required and will not be furnished. Finish per the following as an alternate to Drawing Note #26 and PS 13646:			
		Epoxy Waterborne primer per MIL-PRF-8 e per MIL-PRF-23377, Type I.	85582, Type I, Class 2. Alternate primer, one coat	
ı	2. Apply two topco	ats of Polyurethane per MIL-PRF-85285	i, Type I, color #17925 (White) per FED-STD-595.	
V.		the successful bidder shall provide a copy as) to LILE for final review before produc	by of the processing documentation (routing documents and ction begins.	
W.			review and accept MRB'S prior to shipment of discrepant g drawing package will be submitted for MRB disposition.	
Χ.	specifications, and s component/assembly	standards called out and required for the n y. Contractor is responsible to completely	ernment in writing, full compliance with manuals, manufacture of this contracted landing gear search these manuals, specifications, and standards and fully guear components. Any questions can be forwarded to this	

office, OO-ALC/LGHLEN.

PREPARED BY	SYMBOL	DATE
DAVID H. ARGYLE	LGMPM	25 Nov 03

B B	ENGINEERING DATA REQUIREMENTS CONTINUATION SHEET (ATTACHMENT "A")
PART NUMBER	NATIONAL STOCK NUMBER
68A412704-1003	1620-01-445-0092

- Y. The required forging shall be procured from the qualified forging source, using the original certified forging procedures and dies/tooling.
 - 1. Prior to contract award, the detail part bidder shall provide certification, from the forging source, to the Government that the certified dies and procedures are available and that the forging source has an agreement with the detail parts bidder to provide forgings for their use in the event they are the successful bidder.
 - Prior to production, forging lot qualification shall be accomplished as specified on the forging drawing and SAE AMS-F-7190 (STEEL). The detailed part contractor shall assure that this has been accomplished by the forging source and shall submit certified documentation of accomplishment to the Government.
- Z. FORGING SOURCE, CONTROL AND LOCATION OF DIES:

1. Forging Drawing:

68A412704-2005

2. Die Number:

7782

3. Control of Forging Process:

McDonnel Douglas Corp.

4. Location of Forging Dies:

Kropp Forging Company 5301 West Roosevelt Road Cicero, Illinois 60650-1273

(708) 652-6691

AA. INSTRUCTIONS FOR QUALIFICATION OF NEW FORGING SOURCE.

Prior to contract award, the contractor will advise the government in writing of their intent to procure new forging dies and the proposed forging source. The contractor will not proceed to obtain new dies without the express consent of the government procuring agency. The government will have unlimited use of the dies developed under this contract. The contractor will inform the forging house in writing, at the same time the order for the dies is placed, that the government has unlimited use rights of the dies and forward a copy of this letter to the Contracting Officer.

PREPARED BY	SYMBOL	DATE
DAVID H. ARGYLE	LGMPM	25 Nov 03

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REV:	ENGINEE	RING DATA REQUIREMENTS (ATTACHMENT "A")	
NOTE: MILITARY SPECIFICATION 1. THE FOLLOWING INSTRUCT	ONS I/STANDARDS WILL NOT BE FURNISHED IN THE TIONS ARE FURNISHED FOR THE MANUFACTURE OF	<i>E BID SET.</i> F	
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2. PART NUMBER		3. NATIONAL STOCK NUMBER	
2007602-103		1620-01-252-4042	
4. THE FOLLOWING SPECIFICATION FURNISHED UNLESS SO INDICATION	TIONS/STANDARDS, ETC., WILL BE USED IN LIEU (OF THE DATA INDICATED. THE SUPERSEDI	ED DA T A WILL NOT BE
5. PER DRAWING 200 NOTE 1, USE MATERIA	7602, FLAG NOTE 1, DRAWING 20077 AL SAE AMS 6257 IN LIEU OF MIL-S-	02, FLAG NOTE 5, AND DRAW 8844.	ING 2007652, FLAG
6. HEAT TREAT PER S	SAE AMS-H-6875 AS AN ALTERNATE	TO MIL-H-6875 AND MM4995.	
TREAT. SHALL BE INS	REATED OVER 180 KSI AND ABOVE, SPECTED FOR ABUSIVE GRINDING/N 512. GRINDING SHALL BE PER MIL-	MACHINING BURNS PER MIL-S	ГD-867 AS AN
8. IDENTIFICATION A	AND MARKING PER MIL-STD-130 IN I	LIEU OF TM1040.	
FULL WAVE DIRECT FOLLOWING ACCEPT ALLOWED IS THAT TO SHALL BE NO INDICA	TIC PARTICLE INSPECTION PER AST CURRENT (FWDC), WET CONTINUO ANCE/REJECTION CRITERIA: NO DI HE INSPECTION IS CONDUCTED AT ATIONS ALLOWED. THE INSPECTOR HE INSPECTION PROCEDURE DEVEL	DUS METHOD, FLUORESCENT T EFECTS ALLOWED. THE INTE THE REQUIRED SENSITIVITY I R PERFORMING THE INSPECTION	TYPE WITH THE NT OF NO DEFECTS LEVEL AND THERE ON SHALL BE CERTIFIED
10. SHOT PEEN PER S	SAE AMS-S-13165 IN LIEU OF MIL-S-1	3165.	
11. DIMENSIONS AND	O TOLERANCING PER ASME Y14.5 IN	LIEU OF ANSI Y14.5.	
12. SPECIFICATION N DATA. AS AN ALTER	1M4951 CADMIUM PLATING WILL N NATE USE SPECIFICATION MM5542,	OT BE FURNISHED AS IT IS LIM, CADMIUM PLATING. (PROVI	MITED (PROPRIETARY) DED)
0.004" - 0.007" DEEP II OO-ALC/LGHLEN SHA ACCOMPLISHED AS F NAMED ON THE CON BY A DASH AND A SE INTERMITTENT CONT OF THE PRIOR CONTI SHOULD BEGIN USING 98747-03-001".	SHALL BE VIBROPEENED (WITH VIB N THE LOCATION INDICATED. IF THE ALL PROVIDE S/N LOCATION INSTRU- FOLLOWS: THE SERIALIZATION SHA TRACT, FOLLOWED BY A DASH AND EQUENTIALLY UNIQUE 3 DIGIT NUM TRACTS SHALL START SERIALIZATI RACT. IF A CONTRACT PRODUCES IN G 4 DIGIT SERIAL NUMBERS. THE S	HE DRAWING DOES NOT INDIC UCTIONS. SERIALIZATION OF ALL BEGIN WITH THE CAGE OI D THE 2 DIGIT YEAR OF MANU IBER. A CONTRACTOR WHO R ON OF ITEM WITH THE NEXT I MORE THAN 999 ITEMS, THE S SERIAL NUMBER SHOULD APPI	TATE A LOCATION, ITEM SHALL BE F THE CONTRACTOR UFACTURE, FOLLOWED RECEIVES NUMEROUS NUMBER IN SEQUENCE ERIAL NUMBER EAR LIKE THIS: "S/N
14. CORROSION PRO	TECTION PER MIL-C-16173, GRADE 1	OR MIL-C-11796, CLASS 1 OR 2	2 IN LIEU OF MM5752.
15. CHROME PLATE	TO DRAWING REQUIREMENTS AND	SAE AMS-QQ-C-320 IN LIEU OF	₹ QQ-C-320.
16. SURFACE TEXTU	RE PER ASME B46.1 IN LIEU OF ASA	B46.1.	
PREPARED BY		SYMBOL	DATE
CAROL HYER		LGMPM	1 Dec 03

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A	(ATTACHMENT "A")
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- 18. INSTALL BUSHINGS PER THE FOLLOWING IN LIEU OF MM5743:
- A. THE BUSHING INSTALLATIONS SHALL BE ACCOMPLISHED IN SUCH A MANNER AS TO AVOID DAMAGE TO THE FINISH ON THE I.D. OF THE HOUSING INTO WHICH THE BUSHING IS INSTALLED, OR THE FINISH OF THE O.D. OF THE BUSHING. FORCED INSTALLATION OF SUB-ZERO INSTALLATIONS, SUCH AS THE USE OF A PRESS OR HAMMER IS NOT PERMITTED, AND IS NOT ACCEPTABLE. A SMALL NON-METALLIC HAMMER MAY BE USED TO TAP THE BUSHING INTO ALIGNMENT WITH THE HOUSING BORE, OR TO SEAT THE BUSHING.
- B. PRIOR TO BUSHING INSTALLATION, THE PARTS AND HOUSING BORE SHALL BE CLEANED WITH A CLEANING SOLVENT TO REMOVE ALL CONTAMINATION.
- C. LIQUID NITROGEN SHALL BE USED FOR ALL SUB-ZERO INSTALLATIONS UNLESS SOME OTHER SUB-ZERO COOLANT IS SPECIFIED, AND APPROVED BY OO-ALC/LGHLEN ENGINEERING. THE SOAK TIME OF THE BUSHING IN THE LIQUID NITROGEN SHALL BE SUFFICIENT TO ALLOW THE BUSHING TO REACH THE SAME TEMPERATURE AS THE COOLANT.
- D. THE BUSHING SHALL BE INSTALLED INTO THE HOUSING IMMEDIATELY UPON REMOVAL FROM THE COOLANT WITH AN ABSOLUTE MINIMUM OF LOST TIME. TRIAL RUNS SHALL BE ACCOMPLISHED AS NECESSARY TO MINIMIZE INSTALLATION TIME WHICH SHOULD BE IN THE ORDER OF ABOUT SEVEN (7) SECONDS MAXIMUM.
- E. IT MAY OCCASIONALLY BE NECESSARY TO HEAT THE HOUSING INTO WHICH THE BUSHING IS TO BE INSTALLED, IN ADDITION TO SUB-ZERO COOLING OF THE BUSHING. DETAIL PARTS IN PROCESS WILL NOT HAVE PAINT OR SEALANT OR OTHER ORGANIC MATERIAL APPLIED PRIOR TO HEATING, THE PARTS SHALL BE HEATED BY THE USE OF RADIANT HEAT TECHNIQUES, SUCH AS THERMAL BLANKETS, INFRARED LAMPS ETC.; TO THE MAXIMUM TEMPERATURE OF 250 F. TEMPERATURE MEASURING DEVICES SHALL BE USED TO MONITOR HEAT AND SHALL BE LOCATED ON AREAS OF THE PART EXPECTED TO REACH MAXIMUM TEMPERATURE. NO SCALING, OXIDATION, OR CORROSION SHALL BE PERMITTED.
- F. BUSHINGS WITHOUT FLANGES SHALL BE INSTALLED INTO HOUSING BORE WHICH HAS RECEIVED A LIGHT COAT OF SEALANT PER MIL-PRF-81733. INSTALL SHRUNKEN BUSHING AND WIPE OFF ANY EXCESS SEALANT THAT MAY HAVE EXTRUDED AROUND THE PERIPHERY OF BOTH ENDS OF THE BUSHINGS.
- G. BUSHINGS WITH FLANGES SHALL BE INSTALLED IN A SIMILAR MANNER AS PARAGRAPH (F) EXCEPT SEALANT SHALL ALSO BE APPLIED TO FACE OF LUG UNDER FLANGE. SEALANT SHALL BE APPLIED IN SUCH A MANNER AS TO ENSURE COMPLETE COVERAGE OF INSIDE FACE OF BUSHING FLANGE WHEN BUSHING IS INSTALLED. WIPE OFF ANY EXCESS SEALANT AROUND PERIPHERY OF BUSHING FLANGE. WIPE ANY EXCESS SEALANT FROM OTHER END OF BUSHING ALSO.
- H. FOR BUSHINGS WITH EXTERNAL GREASE GROOVES THE INSIDE OF THE LUG WILL BE COATED WITH MIL-C-16173 PRIOR TO BUSHING INSTALLATION AND FACE OF LUG WILL BE COATED WITH MIL-PRF-81733 PER PARAGRAPH G, IF BUSHING IS FLANGED.
- 19. APPLY A THIN UNIFORM COATING OF PRIMER PER MIL-PRF-23377 OR MIL-PRF-85582 (AFTER CADMIUM PLATING) TO ALL BUSHING BORES AND ALLOW TO FULLY CURE PRIOR TO INSTALLATION OF BUSHING (PRIMER SHALL NOT OBSTRUCT GREASE PASSAGES).

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CAROL HYER	LGMPM	1 Dec 03
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- 20. CLEANLINESS PER SAE AMS 2300 IN LIEU OF AMS 2300.
- 21. APPLY DRY FILM LUBRICANT PER MIL-L-23398 TYPE I, AS AN ALTERNATE TO MM1920.
- 22. CADMIUM PLATE TO DRAWING REQUIREMENTS AND SAE AMS-QQ-P-416 IN LIEU OF QQ-P-416.
- 23. PER DRAWING 2007409, USE MATERIAL 4330V MODIFIED STEEL PER SAE AMS 6411 IN LIEU OF AMS 6411.
- 24. PAINT REQUIREMENTS AS FOLLOWS:
- A. APPLY ONE COAT EPOXY WATERBORNE PRIMER PER MIL-PRF-85582, TYPE I, CLASS 2. ALTERNATE ONE COAT OF EPOXY POLYAMIDE PRIMER PER MIL-PRF-23377, TYPE I IN LIEU OF MIL-P-23377.
- B. APPLY TWO TOPCOATS POLYURETHANE PER MIL-PRF-85285, TYPE I, COLOR NUMBER 17925 (WHITE) PER FED-STD-595 IN LIEU OF MIL-C-83286.
- 25. PERFORM FLUORESCENT PENETRANT INSPECTION PER ASTM E1417, TYPE I, METHOD B OR C, LEVEL 3 OR 4, AS AN ALTERNATE TO MIL-I-6866, WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED. THE INTENT OF NO DEFECTS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE SHALL BE NO INDICATIONS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTION SHALL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURE DEVELOPED BY A LEVEL III AS SPECIFIED IN AIA/NAS NAS-410.
- 26. PER DRAWINGS 2007404-83 AND 2007404-97 USE MATERIAL 7075-T73 AL ALLOY BAR PER SAE AMS-OO-A-225/9 IN LIEU OF OO-A-225/9, OR SAE AMS-OO-A-200/11 IN LIEU OF OO-A-200/11.
- 27. PER DRAWING 2006622, FLAG NOTE 12, USE MATERIAL SAE AMS-S-5000 IN LIEU OF MIL-S-5000 OR AMS 6414 IN LIEU OF MIL-S-8844, CLASS 1.
- 28. THREADS TO BE SAFETY CRITICAL.
- 29. OO-ALC/LGHLEN SYSTEM ENGINEERING RETAINS ALL RIGHTS TO REVIEW AND ACCEPT MATERIAL REVIEW BOARD (MRB'S) DISPOSITIONS PRIOR TO SHIPMENT OF DISCREPANT ITEM. ALL DEVIATIONS, MINOR AND MAJOR, FROM THE ENGINEERING DRAWING PACKAGE SHALL BE SUBMITTED FOR MRB DISPOSITION.
- 30. PRIOR TO CONTRACT AWARD, THE CONTRACTOR SHALL CERTIFY TO THE GOVERNMENT IN WRITING FULL COMPLIANCE WITH MANUALS, SPECIFICATIONS, AND STANDARDS CALLED OUT AND REQUIRED FOR THE MANUFACTURE OF THIS CONTRACTED LANDING GEAR COMPONENT/ASSEMBLY. CONTRACTOR IS RESPONSIBLE TO COMPLETELY SEARCH THESE MANUALS, SPECIFICATIONS, AND STANDARDS AND FULLY UNDERSTAND THE REQUIREMENTS NECESSARY TO MANUFACTURE LANDING GEAR COMPONENTS. ANY OUESTIONS CAN BE FORWARDED TO OO-ALC/LGHLEN.
- 31. AFTER CONTRACT AWARD, THE SUCCESSFUL BIDDER SHALL PROVIDE A COPY OF THE PROCESSING DOCUMENTATION (ROUTING DOCUMENTS AND PROCESS SPECIFICATIONS) TO LIGHLEN FOR FINAL REVIEW BEFORE PRODUCTION BEGINS.

PREPARED BY	SYMBOL	DATE
CAROL HYER	LGMPM	1 Dec 03
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EV:	ENGINEERING DAT	A REQUIREMENTS CONTINUATION SH (ATTACHMENT "A")	HEET
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RIGINAL CERTI A. PRIOR TO O HE FORGING SO	ED FORGING WILL BE PROCURED FROM FIED FORGING PROCEDURES AND DIES/CONTRACT AWARD, THE DETAILED PARTIES, TO THE GOVERNMENT THAT THE THE FORGING SOURCE HAS AN AGREEN THEIR USE IN THE EVENT THEY ARE THE	TOOLING. RT BIDDER SHALL PROVIDE CE E CERTIFIED DIES AND PROCE MENT WITH THE DETAIL PART	RTIF <u>I</u> CATION, FROM DURES ARE
HE FORGING DI	PRODUCTION, FORGING LOT QUALIFICA RAWING AND SAE AMS-F-7190 FOR STEE DETAILED PART CONTRACTOR SHALL A DURCE AND SHALL SUBMIT CERTIFIED I	L FORGINGS AND SAE AMS-A-2 ASSURE THAT THIS HAS BEEN	ACCOMPLISHED BY
3. FORGING SC	DURCE, CONTROL AND LOCATION OF DI	ES:	
A. FORGING	DRAWING: 2007702-1		
B. DIE NUMB	ER: 10824		
C. CONTROL	OF FORGING PROCESS: GOODRICH		
D. LOCATION	N OF FORGING DIES:		
SIFCO IND., I SIFCO FORGE 970 EAST 64T CLEVELAND, PHONE: 216-4 POC: MARIL CAGE: 78226	E GROUP H STREET OH 44103-1620 432-6287		
PREPARED BY		SYMBOL	DATE
CAROL	HYER	LGMPM	1 Dec 03

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	MANUFACTURER NAME GOODRICH	JRER NAME:					REFEF 200764	REFERENCE NR: 2007602-103	NOUN : PISTON, LANDING GEAR	DING GEAR	NSN : 1620012524042
CAGE	DRAWING NUMBER	NUMBER		REV S	NR NI SHEETS CA	NR FUR CARDS COD	FURN DIST	NOUN		REQUIREMENTS	
39661	MM4 990		_		0000	S 0000		HEAT TREAT SPECIFICATION			
17576	17576 MMS542		\		0000	S 0000		CADMIUM PLATING SPECIFICATION			
98747	98747 OO-ALC FORM 462		_	4	0004 00	x 0000		ENGR DATA ROMTS (ATTACH A)			
17576	17576 2006622		_	æ	0001 00	s 0000		BUSHING, AXLE - NLG SHOCK STRUT			
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17576	2007404-77		_		0001 00	S 0000		BUSHING, SLEEVE - LANDING GEAR			
	/98C0297							1	ECO		
17576	17576 2007404-79		_		0001 00	S 0000		BUSHING, SLEEVE - LANDING GEAR			
	/98C0298							1	ECO		
17576	17576 2007404-97		_		0001 00	S 0000		BUSHING, SLEEVE LANDING GEAR			
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	/9700384							1	ECO		
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								FURNISHED WITH CONTRACT AWARD		(NOT PROVIDED).	AVAILABLE.

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IONS ARE FURNISHED FOR THE MANUFACTURE O	F	
ER SHOCK STRUT, MLG		
TIONS/STANDARDS, ETC., WILL BE USED IN LIEU TED.	OF THE DATA INDICATED. THE SUPERSEDI	ED DATA WILL NOT BE
STEEL PER SAE AMS 6257 IN LIEU O	F MIL-S-8844.	
REATED 180 KSI AND ABOVE, ANY FOR BURNS PER MIL-STD-867. GRIN	SURFACES GROUND/MACHINE IDING SHALL BE PER MIL-STD-	D AFTER HEAT TREAT 866 IN LIEU OF MM5759.
CURRENT (FWDC), WET CONTINUC ANCE/REJECTION CRITERIA: NO D HE INSPECTION IS CONDUCTED AT ATIONS ALLOWED. THE INSPECTO!	DUS METHOD, FLUORESCENT T EFECTS ALLOWED. THE INTEN THE REQUIRED SENSITIVITY L R PERFORMING THE INSPECTION	TYPE WITH THE NT OF NO DEFECTS EVEL AND THERE ON SHALL BE CERTIFIED
SPECIFICATION MM4951 WILL NO NATE USE SPECIFICATION MM5542	T BE FURNISHED AS IT IS LIMIT . (PROVIDED)	TED (PROPRIETARY)
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AND MARKING PER MIL-STD-130 A	S AN ALTERNATE TO TM1040.	
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TO DRAWING REQUIREMENTS AND	SAE AMS-QQ-C-320 IN LIEU O	F QQ-C-320.
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THE FORGING SOURCE, TO THE GOVERNMENT THAT THE CERTIFIED DIES AND PROCEDURES ARE AVAILABLE AND THE FORGING SOURCE HAS AN AGREEMENT WITH THE DETAIL PART BIDDER TO I FORGINGS FOR THEIR USE IN THE EVENT THEY ARE THE SUCCESSFUL BIDDER. B. PRIOR TO PRODUCTION, FORGING LOT QUALIFICATION SHALL BE ACCOMPLISHED AS SPECIF THE FORGING DRAWING AND SAE AMS-F-7190 FOR STEEL FORGINGS AND SAE AMS-A-22771 FOR ALL FORGINGS. THE DETAILED PART CONTRACTOR SHALL ASSURE THAT THIS HAS BEEN ACCOMPLISH THE FORGING SOURCE AND SHALL SUBMIT CERTIFIED DOCUMENTATION OF ACCOMPLISHMENT TO	HE
THE FORGING DRAWING AND SAE AMS-F-7190 FOR STEEL FORGINGS AND SAE AMS-A-2277 FOR ALC FORGINGS. THE DETAILED PART CONTRACTOR SHALL ASSURE THAT THIS HAS BEEN ACCOMPLISH THE FORGING SOURCE AND SHALL SUBMIT CERTIFIED DOCUMENTATION OF ACCOMPLISHMENT TO	
	ED BY
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L CYMPOL DATE	
PREPARED BY 1 CMPM 1 Dec 03	
CAROL HYER LGMPM 1 Dec 03	of 3

A	ENGIN	EERING DATA REQUIREMENTS CON' (ATTACHMENT "A")	THOM TON SHEET
ART NUMBER		NATIONAL STOCK NUMBER	
2007107-1		1620-01-252-4035	;
3. FORGING SOURCE, CONTI	ROL AND LOCATION	ON OF DIES:	
A. FORGING DRAWING: 20	007207-1		
B. CONTROL OF FORGING	PROCESS: USAF		
C. LOCATION OF FORGING	G DIES:		
SIFCO IND., INC 970 E. 64th STR. CLEVELAND, OH 44103-162 PHONE: 216-881-8600 POC: MARILYN IRVINE DIE # 10822	0 CICERO, PHONE:	OOSEVELT ROAD IL 60804 708-652-6691 HUCK MEYER	
W. PAT CROW, INC. 200 LUXTON STR P.O. BOX 1720 FT. WORTH, TX 76101-1720 PHONE: 817-536-2861 X280 POC: LAURA RIVERA DIE # 4912			
24. REFERENCE DRAWING 20 RESTRICTIVE FORGING TOLE		B5, REVISE THE FOLLOWING	CONDITIONS DUE TO
CONDITION:	WAS:	<u>NOW</u> :	
THICKNESS TO BE STRAIGHT WITHIN MAX MISMATCH	+.04 /02 .01 .02	+.07 /02 .03 .045	

PAGE 3 OF 3

CAROL HYER

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	REVISION:	90					回	ENGINEERING	DATA LIST		* HISTORY *
DATE:	_	DATA TECH:	SCH		ORGN SYMBOL:	YMBOL			PR NR :	APPLICATION: F-16	PAGE 1 OF 1
CAGE: 13002	MANUFACTURER NAME: GOODRICH	JRER NAME:					REFI 2007	REFERENCE NR: 2007107-1	NOUN : OUTER	NOUN : OUTER CYLINDER ASSY	NSN : 1620012524035
CAGE		NUMBER	_ EE	REV SI	NR NR FURN DIST SHEETS CARDS CODE CODE	TR FUI	RN DIS	T NOUN		REQUIREMENTS	
39661 N	MM4990		_	 -	0000	S 0000		HEAT TREAT SPECIFICATION	ION		
17576 MM5542	1MS 542		-	-	0000	s 0000		CADMIUM PLATING SPECIFICATION	FICATION		
98747	98747 OO-ALC FORM 462		-	4	0003 00	x 0000		ENGR DATA ROMTS (ATTACH A)	CH A)		
17576	17576 2007107		_	ρ	0001 00	S 0000	 	OUTER	- SHOCK STRT MLG		
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STANI	STANDARD ENGINEERING TEXT	ING TEXT	1	1	-	-	-				
ENGI	ENGINEERING DATA LIST REMARKS	IST REMARKS						FURNISHED	FURNISHED METHOD CODE LEGEND:		b
								C - CLASS: S - FURNI: M - STABL	 CLASSIFIED DOCUMENT. FURNISHED WITH SOLICITATION. STABLE BASE DRAWING REQUIRED; 	R - FURNISHED BY PCD UPON REQUEST. P - PARTIAL DOCUMENT FURNISHED. V - VENDOR DRAWING;	0 4
								PURNI	FURNISHED WITH CONTRACT AWARD.	(NOT PROVIDED).	AVAILABLE.
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	REVISION: 01	I: 01						ENGINEE	EERING DATA LIST	LIST		* HISTODY *	Γ
DATE		DATA TECH:	SSF		ORGN SYMBOL:	SYMB	OL :	LGMPM	PR NR:		APPLICATION: T-38	PAGE	
CAGE: 76823		MANUFACTÚRER NAME: NORTHROP GRUMMAN CORP EL SEGUNDO CA	EL S	EGUN	VDO C	A	RE.	REFERENCE NR: 3-41606-3		NOUN: PISTON.L	NOUN : PISTON LANDING GEAR	NSN :	
CAGE	DRAWING	DRAWING NUMBER		REV SI	NR HEETS	NR	NR NR FURN DIST SHEETS CARDS CODE CODE	(ST DE	NOUN		REQUIREMENTS	TOTOGOSTANTI FE	
98747	98747 00-ALC 462/LGMPM	ЬМ	/	<u> </u>	0000	0000	τs	ATCH "A"					
76823	76823 3-40513		/	ы	0000	0000	S	BUSHING - FL	- FLANGED				
76823	76823 3-40526		\	۵	0000	0000	S	PIN - PISTON	PISTON HEAD LOCK				Т
76823	76823 3-40528		\	נו	0000	0000	S	MARKING - LA	- LADING GEAR				1
76823	76823 3-41603		\	Δ	0000	0000	S	COLLAR, LOWE	LOWER TORQUE, NLG				T
76823	76823 3-41605		-	ы	0000	0000	s	PISTON ASSY	ASSY - NLG				T
76823	76823 3-41606		\	U	0000	0000	S	PISTON, NOSE	NOSE LANDING GEAR				T
	/84C451			-						ECO			T
76823	76823 3-41631		-	4	0000	0000	s	BUSHING, TOW	TOWING DISCONNECT - NLG				T
76823	76823 6-41621		\	U	0000	0000	s	RETAINER, LO	RETAINER, LOWER TORQUE COLLAR				-
76823	76823 9756-3		\	₽ P	0000	0000	S	HEAD - PISTO	PISTON, NLG				T
76823	9756C-29			AE 0	0000	0000	S	WASHER, NLG					\top
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ALL GOVERNMENT/MILITARY SPECIFICATIONS AND STANDARDS WILL NOT BE FURNISHED.
TO OBTAIN THESE SPECS AND STDS WRITE TO:
DODSSP
BUILDING 4/SECTION D

700 ROBINS AVE.

PHILADELPHIA PA. 19111-5098 TELEPHONE: (215) 697-2179

TO VIEW OR ORDER: HTTP://WWW.DODSSP.DAPS.MIL FAX: (215) 697-1462

ENGINEERING DATA LIST REMARKS

X - DATA SUPPLIED (NOT IN EDCARS). FURNISHED METHOD CODE LEGEND:

C - CLASSIFIED DOCUMENT.
S - FURNISHED WITH SOLICITATION.
M - STABLE BASE DRAWING REQUIRED.
FURNISHED WITH CONTRACT AWAD

O - OTHERS, CONTRACTOR MUST ACQUIRE. A - DATA NOT R - FURNISHED BY PCD UPON REQUEST.
P - PARTIAL DOCUMENT FURNISHED.
V - VENDOR DRAWING;

G - GOV'T DOCUMENT.

REV:	ENG		ATA REQUIREMENTS CHMENT "A")	
NOTE: MILITARY SPECIFICAT	L IONS I/STANDARDS WILL NOT BE FURNISHE	D IN THE BID SE	<i>T</i> .	
1. THE FOLLOWING INSTRUC	TIONS ARE FURNISHED FOR THE MANUFAC			
	PISTON, NLG			
2. PART NUMBER		3. NATIO	NAL STOCK NUMBER	
3-4	1606-3		1620-00-949-0417 LE	
4. THE FOLLOWING SPECIFIC FURNISHED UNLESS SO INDIC	ATIONS/STANDARDS, ETC., WILL BE USED ATED.	IN LIEU OF THE I	DATA INDICATED. THE SUPERSE	DED DATA WILL NOT BE
5. Markings and Identif	fication per MIL-STD-130 in lieu of	IM-8 and MA	1 -19.9.	
6. Safety Procedures Pe	er NASM20995 and NASM33540 in	Lieu of FH-1	2.	
7. Install Bolts, Screw,	Washers, Pins, Etc. per best shop p	rocedure in L	eu of FH-11 and FH-12.	
8. Aircraft lubricant pe	r MIL-HDBK-838 in Lieu of L-3.			
9. Surface Roughness p	per ANSI B46.1 in Lieu of MIL-STD) -10.		
10. Cadmium Plate per	SAE-AMS-QQ-P-416A Type II, Cl	ass 3 in Lieu	of FP-2.	
11. Heat Treat per SAE	AMS-H6875 in Lieu of HT-3.2.			
12. Solid Film Lubrican	nt per MIL-L-46010 Type 1 or MIL-	L-23398 in L	eu of MAII115 and L-6.	
13. Threads per MIL-St	8879, Safety Critical, in Lieu of FH-	32.		
Wet continuous method, The intent of NO DEFE no indications allowed.	Particle inspection per ASTM E 1444 Fluorescent Type with the following ECTS ALLOWED. is that the inspector performing the inspectas specified in NAS-410.	g acceptance/rection is condu	ejection Criteria: <u>NO DEI</u> cted at the required sensiti	FECTS ALLOWED. vity level and there shall be
with the following Acce is that the inspection is	t penetrant inspection per ASTM E ptance/Rejection Criteria: NO DEF conducted at the required Sensitivity in shall be certified to Level II with the state of the	ECTS ALLOY Level and the	VED. The intent of NO leaves shall be no indications a	DEFECTS ALLOWED Illowed. The inspector
16. Chrome Plate Per M	MIL-STD-1907. Type 1 Class 2 in Li	ieu of FP-6.1.		
17. Shot Peen per SAE	AMS-S-13165 in Lieu of MA-57.			
	d, the successful bidder shall provide To LGHLEN for Final Review befo			(Routing Documents and
19. OO-ALC/LGHLEN prior to shipment of Dis submitted for MRB Disp	I System Engineering retains all right crepant item. All Deviations, Minor position.	nt to review a	nd accept Material Review From the Engineering Drav	Board (MRB's) Dispositions ving Package shall be
PREPARED BY		, SYMBOL		DATE
SANDI L. FIELD			LGMPM	20030210

REV:	ENGINEERING DAT	TA REQUIREMENTS CONTINUATION S (ATTACHMENT "A")	HEET	
PART NUMBER		NATIONAL STOCK NUMBER		
3-41606-3		1620-00-949-0417 LE		
Specifications and Standa Contractor is responsible	rd, the Contractor shall certify to the Governor called out and required for the Manufeto completely search these Manuals, Spectanding Gear Components. Any Question	acture of this contracted landing Ge cifications and Standards and fully t	ar Component/Assembly. Inderstand the requirements	
21. Apply a Thin Unifor Bushing Bores and allow	m Coating of Primer per MIL-PRF-2337 to fully cure prior to installation of Bushi	7 or MIL-PRF-85582 (After CADI ing (Primer Shall Not Obstruct Great	MIUM PLATING) to all ase Passages).	
22. Per Flag Note 8, Dra	awing 2007302, install bushings per the fe	ollowing in Lieu of MM5743:		
Housing into which the b the use of a press or ham	tallations shall e accomplished in such a rushing is installed, or the finish of the burner is not permitted, and is not acceptable ith the housing bore, or to seat the bushing	shing. Forced installation of Sub-Ze. A small non-metallic Hammer m	Zero installations, such as	
B. Prior to Bushing contamination.	g installation, the parts and housing bore	shall be cleaned with a cleaning solu	vent to remove all	
approved by OO-ALC/Lo	shall be used for all Sub-Zero installation. The soak time of the temperature as the coolant.	ns unless some other Sub-Zero cool bushing in the Liquid Nitrogen sha	ant is specified and all be Sufficient to allow the	
D. The Bushing sof lost time. Trail runs so (7) seconds maximum.	hall be installed into the housing immedia hall be accomplished as necessary to mini	ately upon removal from the coolan imize installation time which should	t with an absolute minimum be in order of about seven	
cooling of the bushing. The parts shall be heated maximum temperature of	E. It may occasionally be necessary to heat the housing into which the bushing is to be installed, in addition to sub-zero cooling of the bushing. Detail parts in process will not have Paint, Sealant or other Organic Material Applied prior to Heating. The parts shall be heated by the use of Radiant Heat Techniques, such as Thermal Blankets, Infrared Lamps ETC.; To the maximum temperature of 250F. Temperature measuring devices shall be used to monitor heat and shall be located on areas of the part expected to reach maximum temperature. No scaling, oxidation or corrosion shall be permitted.			
F. Bushings with MIL-PRF-81733. Install Ends of the Bushing.	F. Bushings without Flanges shall be installed into Housing Bore which has received a light coat of Sealant per MIL-PRF-81733. Install shrunken bushing and wipe off any excess sealant that may have extruded around the periphery of Both Ends of the Bushing.			
G. Bushings with Flanges shall be installed in a similar Manner as paragrahp (F) except Sealant shall also be applied to Face of Lug under Flange. Sealant shall be applied in such a manner as to ensure complete coverage of inside faace of bushing flange when bushing is installed. Wipe off any excess sealant around periphery of bushing flange. Wipe off any excess sealant from other end of bushing also.				
H. For Bushings with external Grease Grooves, the inside of the Lug will be coated with MIL-C-16173 prior to bushing installation and face of Lug will be coated with MIL=PRF-81733 per paragraph G, if bushing is flanged.				
PREPARED BY		SYMBOL	DATE	
SANDI L. F	IELD	LGMPM	20030210	
OO-ALC FORM 462, OCT 9	96 (EF-V2) (FormFlow)		PAGE OF	

REV:	ENGINEERING D.	ATA REQUIREMENTS CONTINU (ATTACHMENT "A")	JATION SHEET
PART NUMBER		NATIONAL STOCK NUMBER	***************************************
3-41606-3		1620-00-949-0417 LE	
	ted to 180 KSI and above, any Surface of sper MIL-STD-867. Grinding shall be		Treat shall be inspected for abusive
24. The Forging Shall be Dies/Tooling.	e procured from the Original Forging So	ource, using the Original Ce	ertified Forging Procedures and
Government that the Cert	act Award, The Detailed Part Bidder shaified Dies and Procedures are available s for their use in the event they are the	and the Forging Source has	
AMS-F-7190 for Steel Fo	auction, Forging Lot Qualification shall orgings and Sae AMS-A-22771 for Alumed by the forging source and shall subm	ninum Forgings. The Detail	ed Part Contractor Shall assure that
25. Forging Source, Cor	ntrol and Location of Dies:		
Forging Drawings: 3-4	1606-1F ABD 3-41605-11F.		
Die#: Unknown and 7	874		
Control Of Forging Pro	cess: Northrop		
Location of Forging Die	es:		
KROPP FORGE COMI 5301 W. Roosebelt Roa CICERO, IL 60650-12 PHONE: (708) 652-66 CAGE: OBFN1	d 73		
INTENT TO PROCURE NOT PROCEED TO OB GOVERNMENT PROCU DEVELOPED UNDER T AT THE SAME TIME T	ACT AWARD, THE CONTRACTOR REW FORGING DIES AND THE PRITAIN NEW FORGING DIES WITHOUTHING ACTIVITY. THE GOVERNMENTHIS CONTRACT. THE CONTRACT THE ORDER FOR THE DIES IS PLACE AND FORWARD A COPY OF THIS IS	OPOSED FORGING SOUR UT THE EXPRESS WRITT IENT SHALL HAVE UNLI FOR SHALL INFORM THE CED, THAT THE GOVERN	CCE: THE CONTRACTOR SHALL EN CONSENT OF THE MITED USE OF THE DIES E FORGING HOUSE IN WRITING, MENT HAS UNLIMITED USE
PREPARED BY SANDI L. FIE		SYMBOL	DATE 20030210

SOURCE QUALIFICATION REQUIREMENTS

(PL98-525, SECTION 2319)

STOCK NR (NSN)<u>1620-00-949-0417LE</u> NOUN: Piston, NLG__ PART NUMBER (P/N)<u>3-41606-3</u> AIRCRAFT:T-38

SECTION C

QUALIFICATION REQUIREMENTS THAT MUST BE SATISFIED TO BECOME A QUALIFIED SOURCE:

- 1. Because of the need for uninterrupted item support to military aircraft systems while keeping with the requirements of PL 98-525, the current acquisition need not and generally will not be delayed to provide an offeror an opportunity to qualify. Normal acquisition practices at OO-ALC should preclude the denial of opportunity to any interested offeror.
- 2. The offeror must provide a pre-contract award qualification article, which meets the requirements of the engineering drawings, material specifications, and process specifications. However, successful completion of the qualification testing does not guarantee any contract award. If the offeror is deemed qualified and awarded the contract, a post-contract award first ariticle exhibit may be required to verify production capability.
- 3. The qualification article will be subjected to form, fit, and function verification as well as required testing to assure compliance with data list and other applicable procurement criteria. The qualification article shall demonstrate full compatibility and comparability with existing parts.
- 4. The required materials will be procured from a qualified source and shall meet the requirements of their respective specifications. The offeror will assure that the supplier has accomplished this and shall submit certified documentation of accomplishment of the above requirements to the purchaser along with the precontract award qualification article.
- 5. The required forgings shall be procured from the qualified forging source using the original certified forging procedures and dies. Forging material and lot qualifications shall be accomplished as required in the specified forging drawing, P/N <u>3-41606-3</u> and specification <u>MIL-F-7190</u>. The offeror shall assure that this is or has been accomplished by the forging source and will submit certified documentation of accomplishment of the above requirements to the government along with the pre-contract award qualification article.
- 6. The qualification article once submitted will become subject to such testing as deemed necessary by the U.S. Government to prove that the article meets all dimensional, processing and functional requirements. Such testing may result in the destruction of the article. Following completion of necessary testing and evaluation, the article no matter what its condition shall be returned to the contractor or disposed of at his discretion and direction whether it was found acceptable or not.
- 7. Form verification: The U.S. Government's Quality Verification Center (QVC) will be used to insure compliance with the dimensional requirements of the article. Material and processing compliance will also be verified as required.
- 8. Fit/function verification: Existing components and government test stands and fixtures will be utilized to verify physical interface and functional performance of articles.
- 9. Testing for material and process compliance.

(a) Material analysis

(e) Finish

(b) Heat treat

(f) Grain flow

(c) Grinding

(g) Other

(d) Plating

SOURCE QUALIFICATION REQUIREMENTS

(PL98-525, SECTION 2319)

STOCK NR (NSN)<u>1620-00-949-0417LE</u> NOUN: Piston, NLG__ PART NUMBER (P/N)3-41606-3 AIRCRAFT:T-38

10. Remarks:

- a. Organic verification capabilities exist at OO-ALC.
- b. Testing requirements outside organic capabilities will be contracted out.
- 11. The estimated cost of government testing and evaluation is \$1500.
- 12. Maximum time for testing of the qualification article will not exceed 30 days from receipt at testing agency.

SECTION D

QUALIFICATION WAIVER REQUIREMENTS.

- 1. An offerer who has had previous experience in the manufacture and qualification of items, which can be correlated with this product, may apply to the design control authority at OO-ALC for a waiver of the above stated qualification requirements.
- a. The qualification waiver criteria utilized by the design control authority to perform a qualification analysis are available upon request. The qualification waiver criteria may be used as a guide in preparing the offerer's written input to the design control authority.
- b. The burden of proof for written inputs is on the offerer. The design control authority will not pursue authenticity verification of claims made by the offerer of product manufacturing experience with other Government or non-Government agencies. Unsubstantiated claims will not be considered in the waiver analysis process.
- c. This waiver will be granted if and only if the design control authority LGHLEN can establish the qualifications of the offerer through the evaluation of written inputs from the offerer or from previous knowledge of the offerer's capabilities or from previous experience with the offerer on similar item acquisitions. If there is any doubt about the offerer's capability, the offerer will be required to submit a pre-qualification article. There is no guarantee of qualification by similarity. LGHLEN reserves the right to require a pre-qualification article of all offerers.
- 2. The current acquisition need not and will not be delayed in order to provide an offerer with an opportunity to meet the requirements for qualification waiver.
- 3. Maximum time for approval of qualification by similarity will not exceed 15 days.

	3. INSTRUCTIONS TO CONTRACTING OFFICER: Insert appropriate clause(s) into Section D for applicable item(s) as indicated below. AFMCFARS 6362.247-9006, SHIPPING CONTAINER MARKING. ITEM NAME(s)OR NSN/MMAC	AFMCFARS 5352.247-8006, MARKING OF WARRANTED ITEMS. ITEM NAME(s) OR NSN/MMAC AFMCFARS 5352.247-9007, SPECIFICATION COMMERCIAL PACKAGING (ASTM D3951). ITEM NAME(s) OR NSN/MMAC	AFMCFARS 5352.247-9008, CONTRACTOR COMMERCIAL PACKAGING (Commercial Best Practice). ITEM NAME(s) OR NSN/MMAC	AFMCFARS 5352.247-9009, MILITARY PACKAGING AND MARKING. ITEM NAME(s) OR NSNAMAC AFMCFARS 5352.247-9010, ENGINEERED OR SPECIALIZED CONTAINERS (CDRS). ITEM NAME(s) OR NSNAMAC	AFMCFARS 5352.247-9011, PACKAGING AND MARKING OF HAZARDOUS MATERIAL, ITEM NAME(s) OR NSN/MMAC	AFMCFARS 5352.247-9013, PACKAGING DATA (Coded and/or Special Packaging Instructions). ITEM NAME(s) OR NSN/MMAC	LENGTH 10 WIDTH 10 DEPTH 10 WHOLE CUBE 1000TH	DATE 3003/7/8 SEE REVERSE SIDE
PACKAGING REQUIREMENTS	1. PACKAGING REQUIREMENTS: Block 1 shall always be completed and further defined in Blocks 2, 3, or 4. The term "Item ID" refers to line item number, item name, NSN/MMAC, part number, or any other way of identifying a particular item. MiL-STD-2073-1 represents whiltery Preservation (PRES) and Packing (PACK). Military packing consists of levels A, B, and Minimum (M). ASTM D3951 could be substituted by another document if specified in Block 2. Quantity Per Unit Pack (QUP) and Commercial Best Practice (CBP) are abbreviated. The reverse side of this form has the European Union environmental requirements.	ITEM ID AIL-STD-2073-1 ASTM D3951 CBP INSTRUCTION PRES PACK PRES PACK PRES PACK NUMBER NUMBER	162000940417 0037 1620003490750	KAGING AND CONTAINER MARKING REQUIREMENTS (Specify all revisions and dates of required specific		4. CODED DATA: Coded	100 METH D MTL MTL DUNN T CONT CON L MKGHT LOOK CONTRACT	ORGANIZATION L G M P L S LOG30408 (EF-V1) PACKAGING SPECIALIST (Typed Name/Signature) PACKAGING SPECIALIST (Typed Name/Signature) PACKAGING SPECIALIST (Typed Name/Signature) PACKAGING SPECIALIST (Typed Name/Signature)

ND F01-252-4042	SPI
01-252-404	5
	01-252-404

SPECIAL PAC	CKAGING INSTRUCT	CDDE ID 98747	SPI NO. (TPO) F01-252-4042		
			33.17	SHEET 1 OF 2	
PART OR DRAWING NO.	NATIONAL STOCK NO.	CURRENT REV	ILL. T. LUCERD		
2007602-103	В	CHK. T. ZIMM	IERMAN		
ITEM NOME	ORIGINAL	ENGR. K.W. DL	.SON		
PISTON A	DATE 89167	AUTH. A. BRIM	1HALL		

MILITARY PRESERVATION IAW MIL-STD-2073 SERVICEABLE METHOD 20 UNSERVICEABLE METHOD QUP 001

000

CLEANING & DRYING IAW MIL-STD-2073

PRESERVATIVE MIL-PRF-16173, GR 2, CDDE 02

MARKING IAW MIL-STD-129 SPECIAL MARKINGS:

A) SPI NO. F01-252-4042

MARK THE SPI NUMBER ON ONE SIDE OF THE CONTAINER AND ON ALL REMOVABLE DUNNAGE. MARK REUSABLE CONTAINER DO NOT DESTROY

CLOSURE IAW PPP-B-621 CAUTION NOTICE

1. THIS PISTON HAS A HISTORY OF CORROSION. INSURE THE PRESERVATIVE IS APPLIED AS INSTRUCTED IN NOTE 1.

NOTES:

ICQ

1. APPLY MIL-PRF-16173, GRADE 2 PRESERVATIVE ON ALL BARE METAL SURFACES, INCLUDING INSIDE HOLLOW TUBE OF THE PISTON ASSEMBLY. INSURE ALL SURFACES ARE COMPLETELY COVERED. WRAP PRESERVED EXPOSED SURFACES WITH -5 AND SECURE IN PLACE WITH A-A-883 TAPE OR EQUAL.

PACKING AS SPECIFIED BELOW AND BILL OF MATERIALS VRTY GR TYPE CL STYLE LEVEL. SPEC 2 A PPP-B-621 (MDD) Α В 1 B PPP-B-621 (MOD)

	LEVEL	A LEVEL B	
GROSS CU FT	2.474	2.474	
GROSS WT LBS	54	54	
DESIGN FRAGILIT	Y G 100	100	
	LENGTH	WIDTH	DEPTH
CNTR I.D.	35	11	8
CNTR D.D.	38	12 1/2	9
ITEM DIM	32	9	5 1/2
ITEM WT LBS	31		

		REVISIONS	
	LTR	DESCRIPTION	DATE
Γ	Α	ADD NOTES & UPDATE	99129
	В	UPDATE/ADD WOOD STATEMENT	01320

- SOURCE OF SUPPLY FOR TORQUE WASHERS, CATALOG NO. MS-98398K2915: TRW FASTENER DIV.
- 31 AMES ST.

CAMBRIDGE, MASS. 02142, OR LOCAL PURCHASE

3. PISTONS PACKED IN PREVIOUS ADDITIONS OF THIS SPI DO NOT REQUIRE REPACKING IF THE INTEGRITY OF THE SPI IS NOT COMPROMISED.

NOTICE 1: TRAFFIC MANAGEMENT OFFICES OR ANY ACTIVITY BUYING SOLID WOOD MATERIAL TO USE FOR BUILDING OR ASSEMBLING PACKAGING MUST COMPLY WITH THE FOLLOWING REQUIREMENT FOR PURCHASING THE WOOD: "ALL WOODEN PALLETS AND WOOD CONTAINERS PRODUCED OF NON-MANUFACTURED WOOD SHALL BE CONSTRUCTED FROM HEAT TREATED (HT TO 56 DEGREES CENTIGRADE FOR 30 MINUTES) MATERIAL AND CERTIFIED BY AN ACCREDITED AGENCY RECOGNIZED BY THE AMERICAN LUMBER STANDARDS COMMITTEE (ALSC) IN ACCORDANCE WITH NON-MANUFACTURED WOOD PACKING POLICY AND NON-MANUFACTURED WOOD PACKING ENFORCEMENT REGULATIONS BOTH DATED MAY 30, 2001." THESE DOCUMENTS CAN BE FOUND AT WWW.APHIS.USDA.GOV.

-12	A/R	TAPE	1 X A/R	A-A-883	TYPE I OR II	
11	6	NUTS	3/8	FF-N-836	TYPE II, STYLE 4	_] =
-10	6	WASHERS	3/8	FF-W-92	TYPE A, GRADE I, CLASS A	Ē
9	6	TORQUE WASHERS	to fit 3/8 BOLT	5310-00-936-9	9532 (SEE NOTE 2)] -
8	6	BOLTS	3/8 X 5	FF-B-584	TYPE I, CLASS 1, STYLE A] :
- 7	3	STRAPPING	A/R X 1 1/4 X .035	ASTM-D3953	TYPE I, REG DUTY, FIN B	
-6	3	CUSHIONING	A/R X 3 X 1/4	PPP-PRF-115	TYPE I (CARGO PACK)] [
-5	1	WRAP	20 X 12	MIL-PRF-121	TYPE I, GRADE A, CLASS I	
4	1	WRAP	8 X 8	MIL-PRF-121	TYPE I, GRADE A, CLASS 1	
-3	2	SADDLES	2 X 4 (NDM) X 8	ASTM-D6199	CLASS 2	
-2	1	SADDLE	2 X 4 (NOM) X 7	ASTM-D6199	CLASS 2	
1	2	TOP & BOTTOM	36 1/2 X 12 1/2 X 1/2	A-A-55057	TYPE A	
Ρ/Ν	QTY REQD	NOMENCLATURE OR DESCRIPTION	SIZE (INCHES UNLESS SPECIFIED)	MATER	TAL SPECIFICATION	

SPECIAL PACKAGING INSTRUCTION

CODE ID 98747

SPI NO. (TPO)

F01-252-4042

ITEM NOMENCLATURE PISTON ASSEMBLY

SHEET 2 OF 2

